

Due July 6th or sooner

Work Order ID 60003

June 22, 2010 2:35:08 PM



Page 1

Item ID: D4042-041

Accept



Setup Start



Revision ID:

Item Name: Short Basket Base Assembly, LH

Stop



Start Date: 6/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/02/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

K

Date: *10.06.29* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4042	A

100 Weld per dwg A/R S.S. rod Batch: *10M100775* 0.00
 Large Fab



Large Fab

Memo 0.00

1- assemble ribs , handel plates weld as per dwg D4042
 inspect before welding mesh
 2- tack weld mesh on basket as per dwg D4042 (trim mesh if necessary)
 3- weld hinges, and Mounting brackets as per dwg D4042
 take lid to locate hinge and bracket

PD 10.06.29

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo 0.00

Quality Control

JL 10.06.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action - Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #
Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S. w/ lot 10

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

WATER PRESS.

① BL 10-7-5

PTS →

Memo 1114841

0.00

1- Plug holes prior to

1ST COAT:
START TIME: 11:55
OVEN TEMPERATURE: 400°FINISH TIME: 12:25
***** 2nd coat if necessary *****2ND COAT:
START TIME: 1:00
OVEN TEMPERATURE: 400°
FINISH TIME: 1:30

① BL 10-7-5

W/O:		4042-041	WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
107-5	130	ADD SEQUENCE FOR PRESSURE WASH	BR	10-7-5			
			MM	107-06	1004-06	1007-06	1007-06

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

GP/07/05 Q

150



HandFinish

Hand Finishing

Assemble as per dwg

0.00

Memo

0.00

GP/07/05 Q

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 06/07/06

(H)

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

170



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: GASet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00



Memo

0.00

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NOTE: Date & initial all entries

Picklist Print

June 22, 2010 2:35:04 PM

Page 1 /4

Work Order ID: 60003



Parent Item: D4042-041



Parent Item Name: Short Basket Base Assembly, LH

Start Date: 6/22/10

Required Date: 7/02/10

Comments: IPP RevA: new issue DD 10.01.12 verified by:EC IPP Rev:B as per dwg
revA DD 10.02.18 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4042-043 		Manufactured	No			100	Each	0.0000	1	1			
Aft Rib Assembly 		Manufactured	No			100	Each	0.0000	1		B60009 → ①	PD	10.06.24
Rib Assembly 	D4043-041 	Manufactured	No			100	Each	0.0000	1	1			
Center Rib Assembly 	D4044-043 	Manufactured	No			100	Each	0.0000	2	2			
Fwd Rib Assembly 	D4044-041 	Manufactured	No			100	Each	0.0000	1	1			
Fwd Rib 	D4042-1 	Manufactured	No			100	Each	0.0000	1	1			
Rib 	D4042-5 	Manufactured	No			100	Each	0.0000	1	1			
Rib 	D4042-7 	Manufactured	No			100	Each	0.0000	1	1			
Rib 	D4042-9 	Manufactured	No			100	Each	0.0000	1	1			

W/O:		WORK ORDER CHANGES						
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Page 2 /4

Work Order ID: 60003



Parent Item: D4042-041



Parent Item Name: Short Basket Base Assembly, LH

Start Date: 6/22/10

Required Date: 7/02/10

Start Qty: 1.00

Required Qty: 1.00

D4042-13



Manufactured

No

100

Each

0.0000

1

1

B60017 → ① PD 10.06.24

Rib

D4043-3



Manufactured

No

100

Each

0.0000

1

1

B60018 → ① PD 10.06.24

Rib

D4043-5



Manufactured

No

100

Each

0.0000

2

2

B60020 → ② PD 10.06.24

Rib

D4043-7



Manufactured

No

100

Each

0.0000

2

2

B60025 → ② PD 10.06.24

Rib

X D4044-5



Manufactured

No

100

Each

0.0000

1

1

B60021 → ① PD 10.06.24

Aft Rib

D4042-11



Manufactured

No

100

Each

1.0000

1

1

B60022 → ① PD 10.06.24

Rib

Location	Loc Qty	Loc Code
----------	---------	----------

WA

56163

Loc Qty

1

1

Loc Code

D4045-1



Manufactured

No

100

Each

0.0000

3

3

B60023 → ③ PD 10.06.24

Lug

D4046-1



Manufactured

No

100

Each

0.0000

1

1

B60024 → ① PD 10.06.24

Mesh Basket Base

W/O:

WORK ORDER CHANGES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

June 22, 2010 2:35:05 PM

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Work Order ID: 60003



Parent Item: D4042-041



Parent Item Name: Short Basket Base Assembly, LH

Start Date: 6/22/10

Required Date: 7/02/10

Start Qty: 1.00

Required Qty: 1.00

D4046-3



Manufactured

No

100

Each

1.0000

1

1

RD 10.06.23

Mesh Fwd End

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	1	
56403	1	

D4046-5



Manufactured

No

100

Each

1.0000

1

1

RD 10.06.23

Mesh Aft End

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	1	
56404	1	

D4016-1



Manufactured

No

100

Each

9.0000

3

3

RD 10.06.23

Hinge Half, Base

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	9	
59536	9	

D4021-1



Manufactured

No

100

Each

19.0000

4

4

RD 10.06.23

Handle Plate

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST109	5	
57086	5	
WA	14	
59336	5	
59746	9	

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Picklist Print

June 22, 2010 2:35:06 PM

Page 4

Work Order ID: 60003



Parent Item: D4042-041



Parent Item Name: Short Basket Base Assembly, LH

Start Date: 6/22/10

Required Date: 7/02/10

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No 100 Each 41.0000 2 2



Mounting Bracket



10.06.23

Location	Loc Qty	Loc Code
ST	15	
	59124 59265	
WA	15	
	26	
46086	2	
51745	2	
57185	1	
59265	21	

D2931 Manufactured No 150 Each 830.0000 2 2



Bumper



E510/07/06

Location	Loc Qty	Loc Code
ST504	830	
46064	830	

AN960JD8

NAS1149DN832

Purchased

No

↳ M114740 (2)

Washer

MS20600-AD4W3

Purchased

No



Cherry Rivets

Location	Loc Qty	Loc Code
ST321	1645	
106375	3	
107939	822	
111636	820	



E510/07/06



E510/07/06

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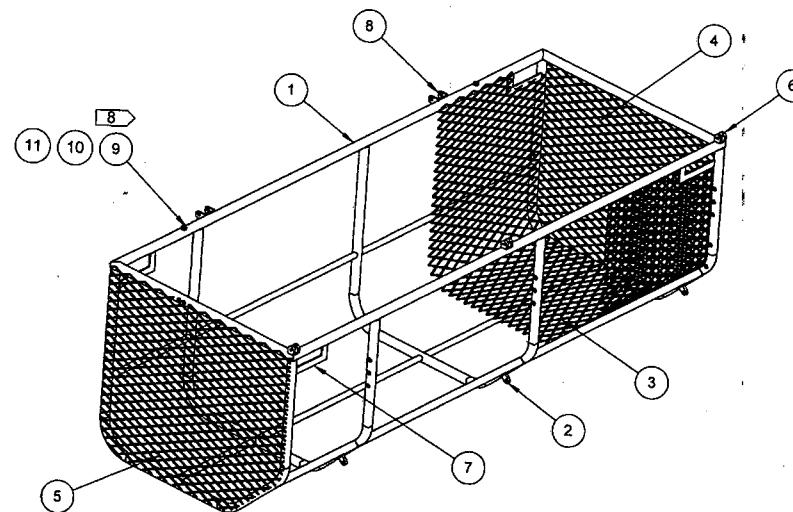
8 7 6 5 4 3 2 1

D

C

B

A



D4042-041 SHORT BASKET ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 28.82 lbs APROX
- 8) INSTALL AFTER FINISH
- 9) TRIM LOCALLY AS REQUIRED TO CLEAR FASTENERS/STRUCTURE
- 10) WELD PER DART QSI 004

ITEM	QTY 041	P/N	DESCRIPTION
	X	D4042-041	SHORT BASKET BASE ASSY, LH
1	1	D4042-101	BASKET BASE FRAME ASSY, LH
2	3	D4045-1	LUG
3	1	D4046-1	MESH BASKET BASE
4	1	D4046-3	MESH FWD END
5	1	D4046-5	MESH AFT END
6	3	D4016-1	HINGE HALF, BASE
7	4	D4021-1	HANDLE PLATE
8	2	D2581	MOUNTING BRACKET
9	2	D2931	BUMPER
10	2	AN960JD8	WASHER
11	2	MS20600AD4W3	RIVET

SHOP COPY.
RETURN TO
ENGINEERING
UNCONTROLLED CQTY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60003

BS 10-6-22

RELEASED
2010-02-16
JW

A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>PP</i>		
MFG. APPR.	<i>KS</i>		
APPROVED	<i>MP</i>	DRAWING NO.	REV. A
DE APPR.	<i>MP</i>	D4042	SHEET 1 OF 11
TITLE		SCALE	NTS
DATE 10.01.29		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT MAY NOT BE COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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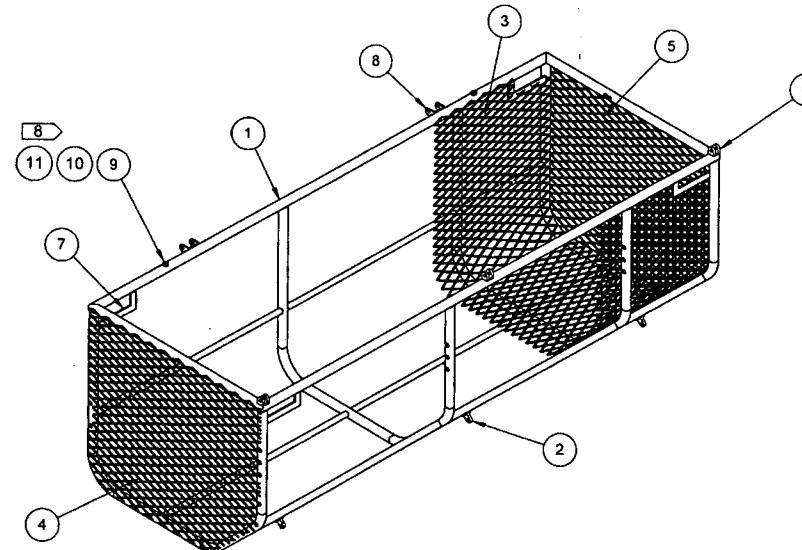
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2

ITEM	QTY	P/N	DESCRIPTION
	X	D4042-042	SHORT BASKET BASE ASSY, RH
1	1	D4042-102	BASKET BASE FRAME ASSY, RH
2	3	D4045-1	LUG
3	1	D4046-1	MESH BASKET BASE
4	1	D4046-3	MESH FWD END
5	1	D4046-5	MESH AFT END
6	3	D4016-1	HINGE HALF, BASE
7	4	D4021-1	HANDLE PLATE
8	2	D2581	MOUNTING BRACKET
9	2	D2931	BUMPER
10	2	AN960JD8	WASHER
11	2	MS20600AD4W3	RIVET



- NOTES:
 1) MATERIAL: N/A
 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: 28.82 lbs APPROX
 8) INSTALL AFTER FINISH
 9) TRIM LOCALLY AS REQUIRED TO CLEAR FASTENERS/STRUCTURE
 10) WELD PER DART QSI 004

D4042-042 SHORT BASKET ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-02-16
NP

8 7 6 5 4 3 2 1

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RP	DRAWING NO.	REV. A
MFG. APPR.		D4042	SHEET 2 OF 11
APPROVED		TITLE	SCALE
DATE	10.01.29	SHORT BASKET BASE ASSY NTS	

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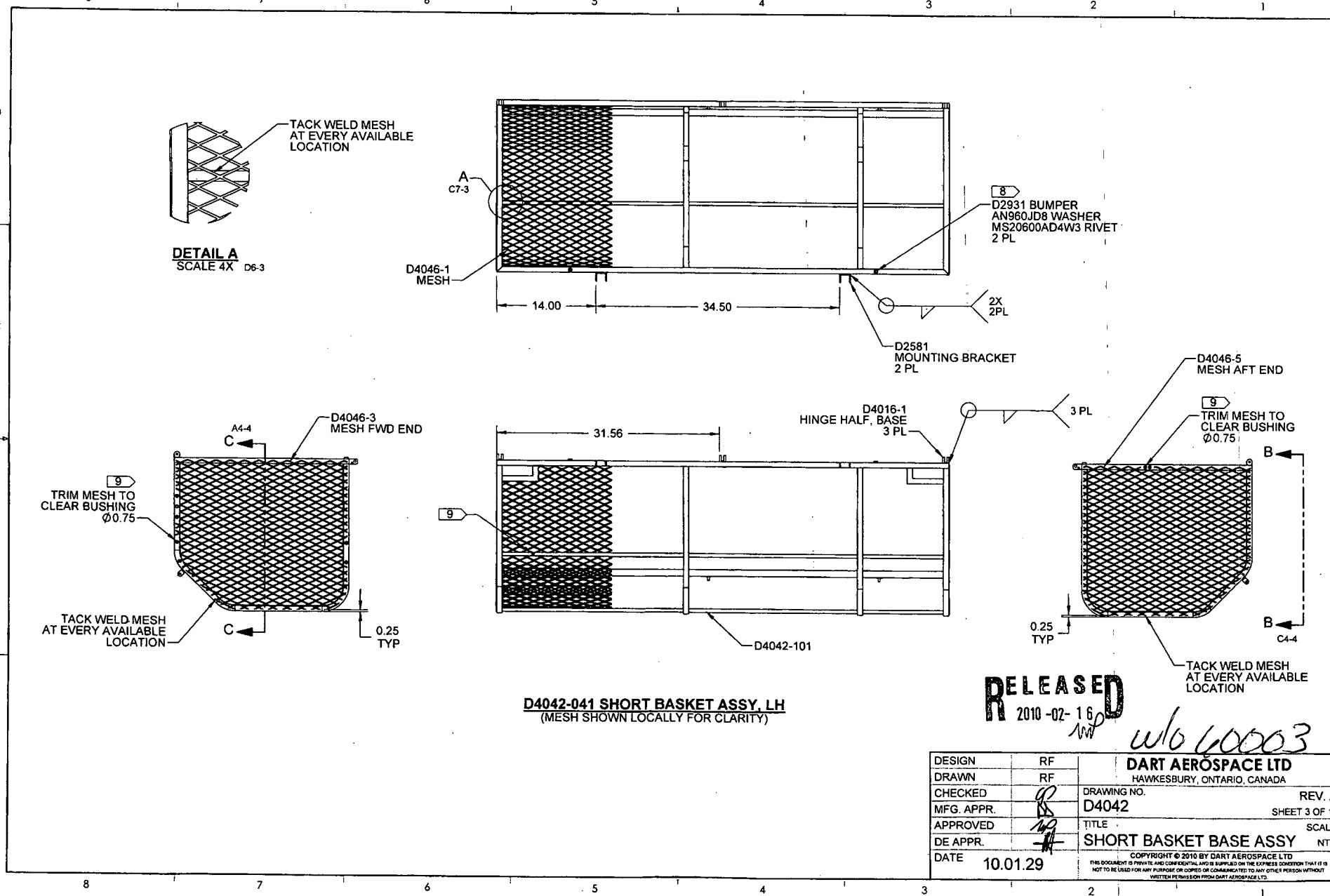
10/6003

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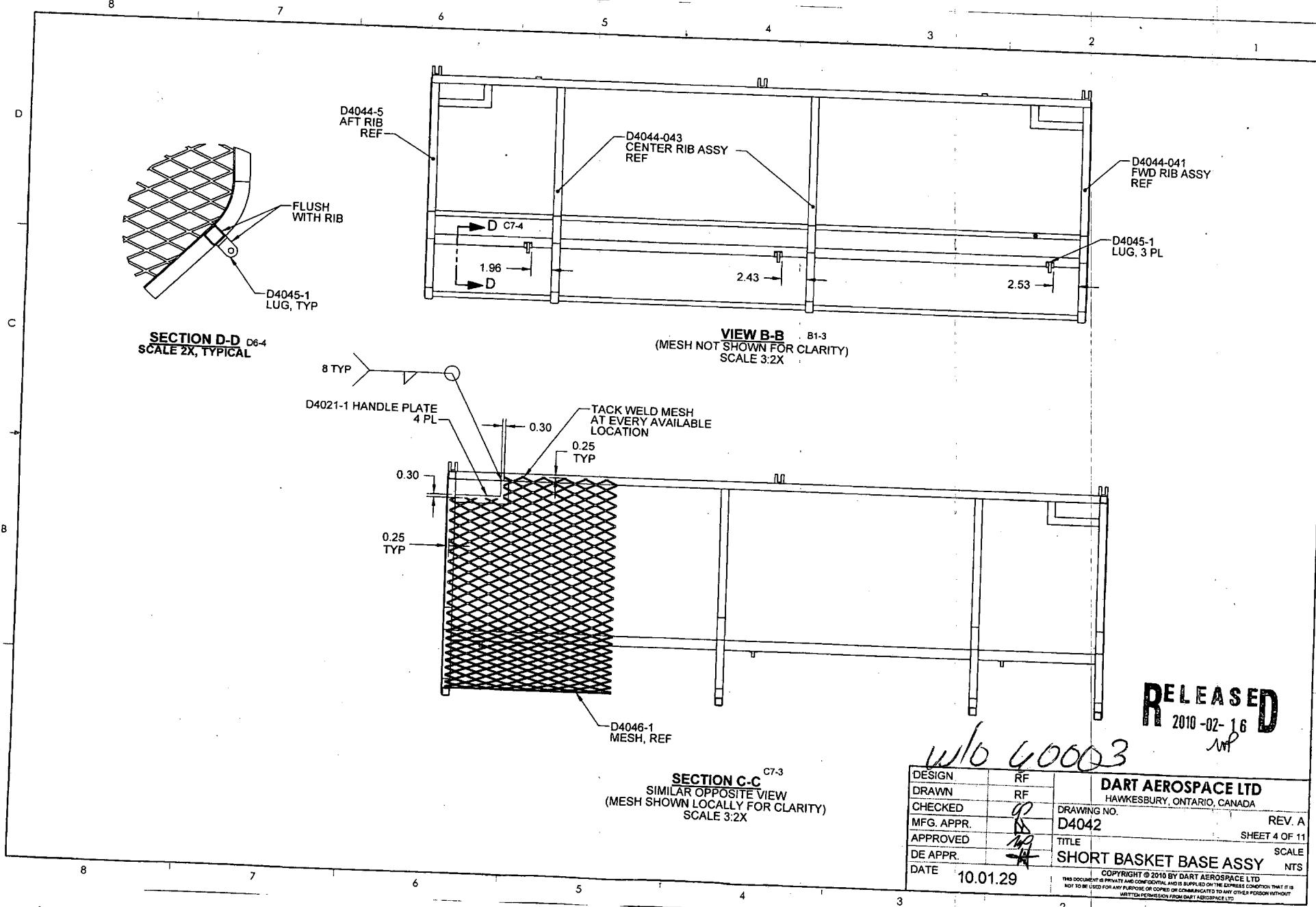


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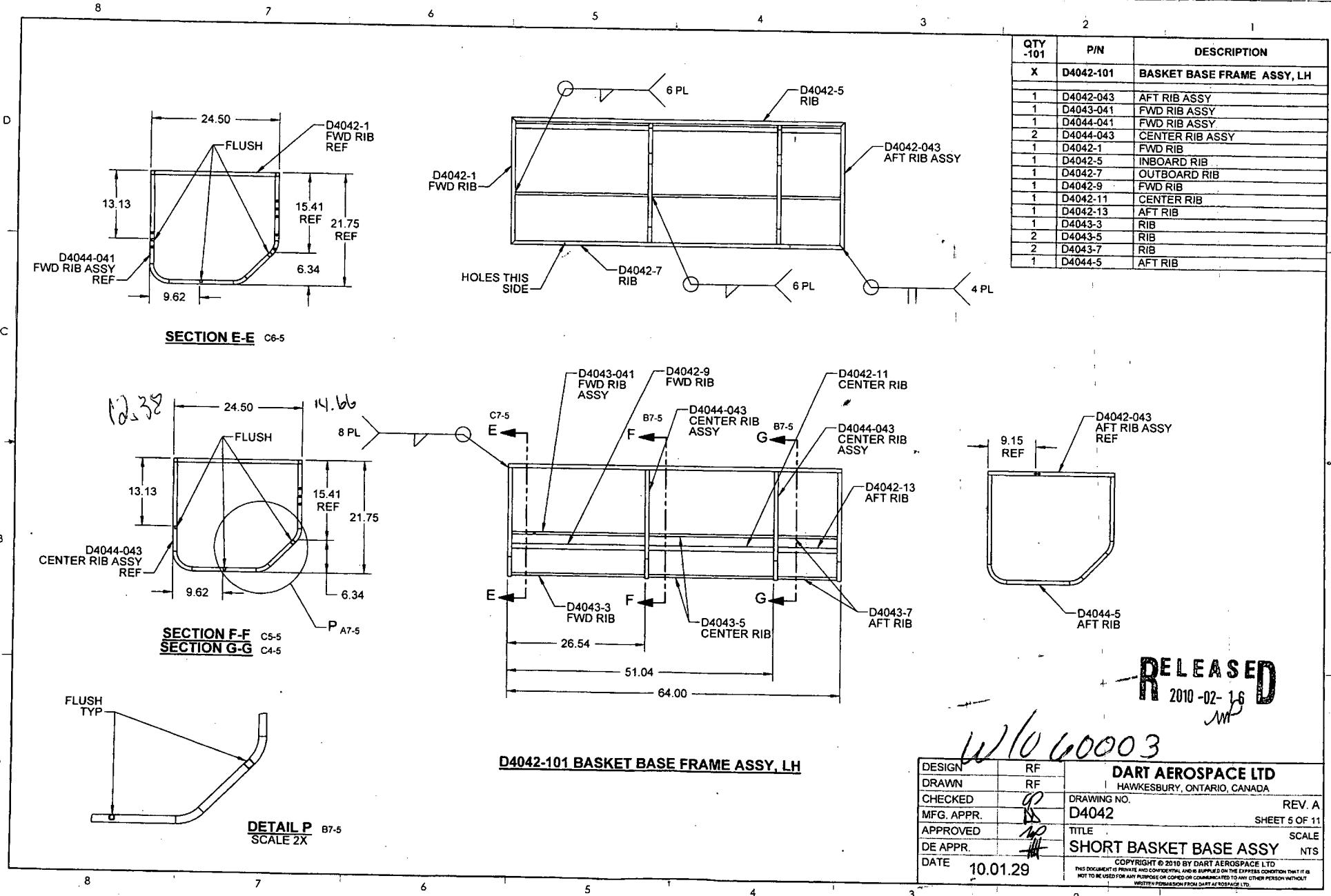


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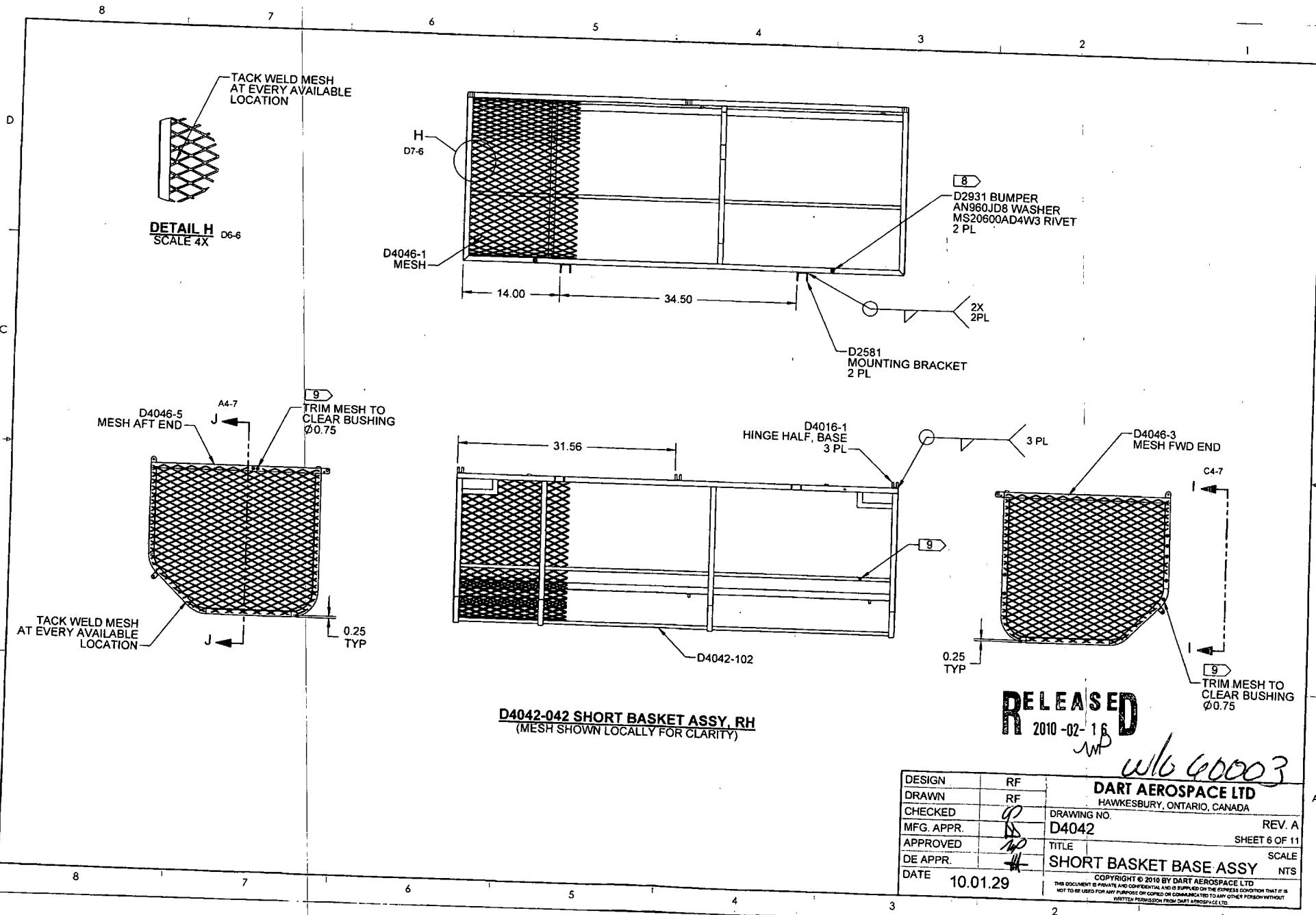
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	NS	D4042	SHEET 5 OF 11
APPROVED	100	TITLE	SHORT BASKET BASE ASSY
DE APPR.	100	SCALE	NTS
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CHECKED	JP	DRAWING NO.
MFG. APPR.	AS	D4042
APPROVED	AS	REV. A
DE APPR.	#	SHEET 6 OF 11
DATE	10.01.29	SCALE
		NTS

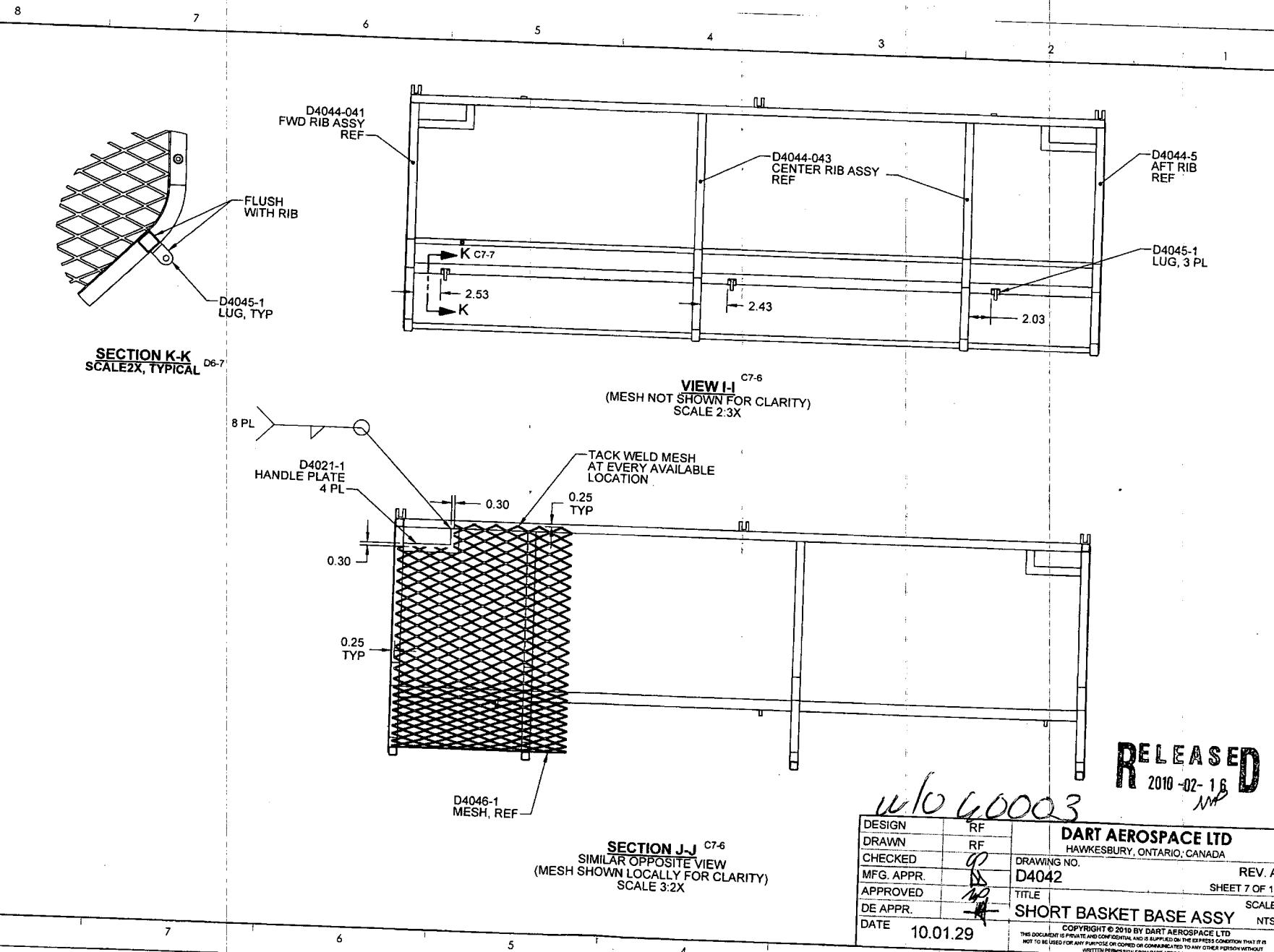
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	99	DRAWING NO.
MFG. APPR.	AS	D4042
APPROVED	MP	REV. A
DE APPR.	MP	SHEET 7 OF 11
DATE	10.01.29	SCALE NTS

10/04/0003

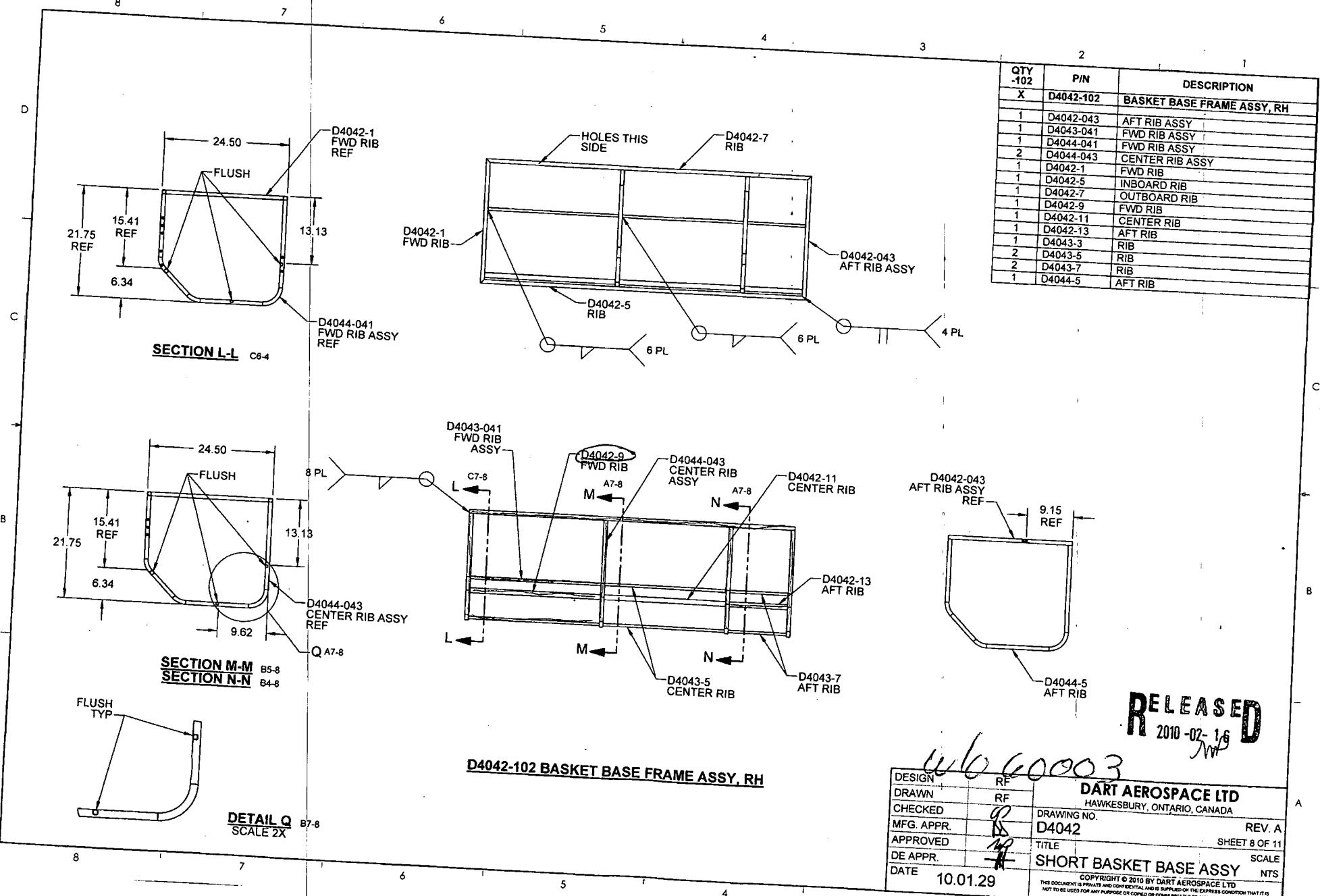
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

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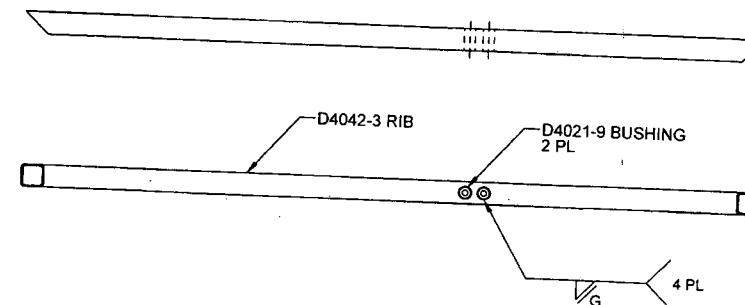
1

D

C

B

A



D4042-043 AFT RIB ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.91 lbs
 - 8) WELD PER DART QSI 004

8

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1

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2010-02-16
W040003

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APPROVED	R	REV. A
DE APPR.	R	SHEET 9 OF 11
DATE	10.01.29	SCALE
		NTS

W040003

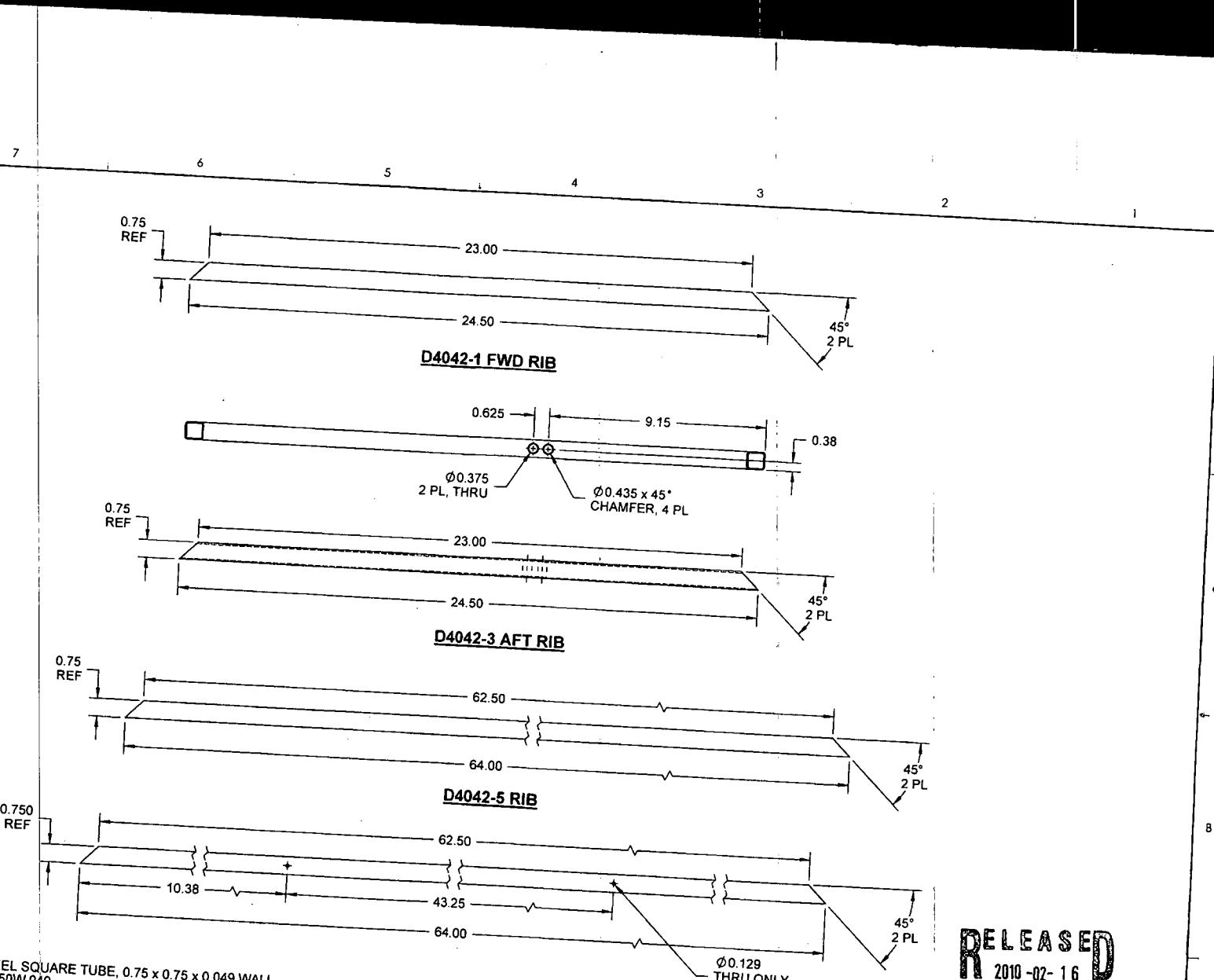
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NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 x 0.75 x 0.049 WALL
 REF DART SPEC. M304TS0.750W.049
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: D4042-1: 0.89 lbs
 D4042-3: 0.88 lbs
 D4042-5: 2.36 lbs
 D4042-7: 2.36 lbs

RELEASED
2010-02-16
JWD

10/10/2023

DESIGN	RF
DRAWN	RF
CHECKED	Q
MFG. APPR.	N
APPROVED	M
DE APPR.	M
DATE	10.01.29

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D4042 REV. A
SHEET 10 OF 11
TITLE SHORT BASKET BASE ASSY
SCALE NTS

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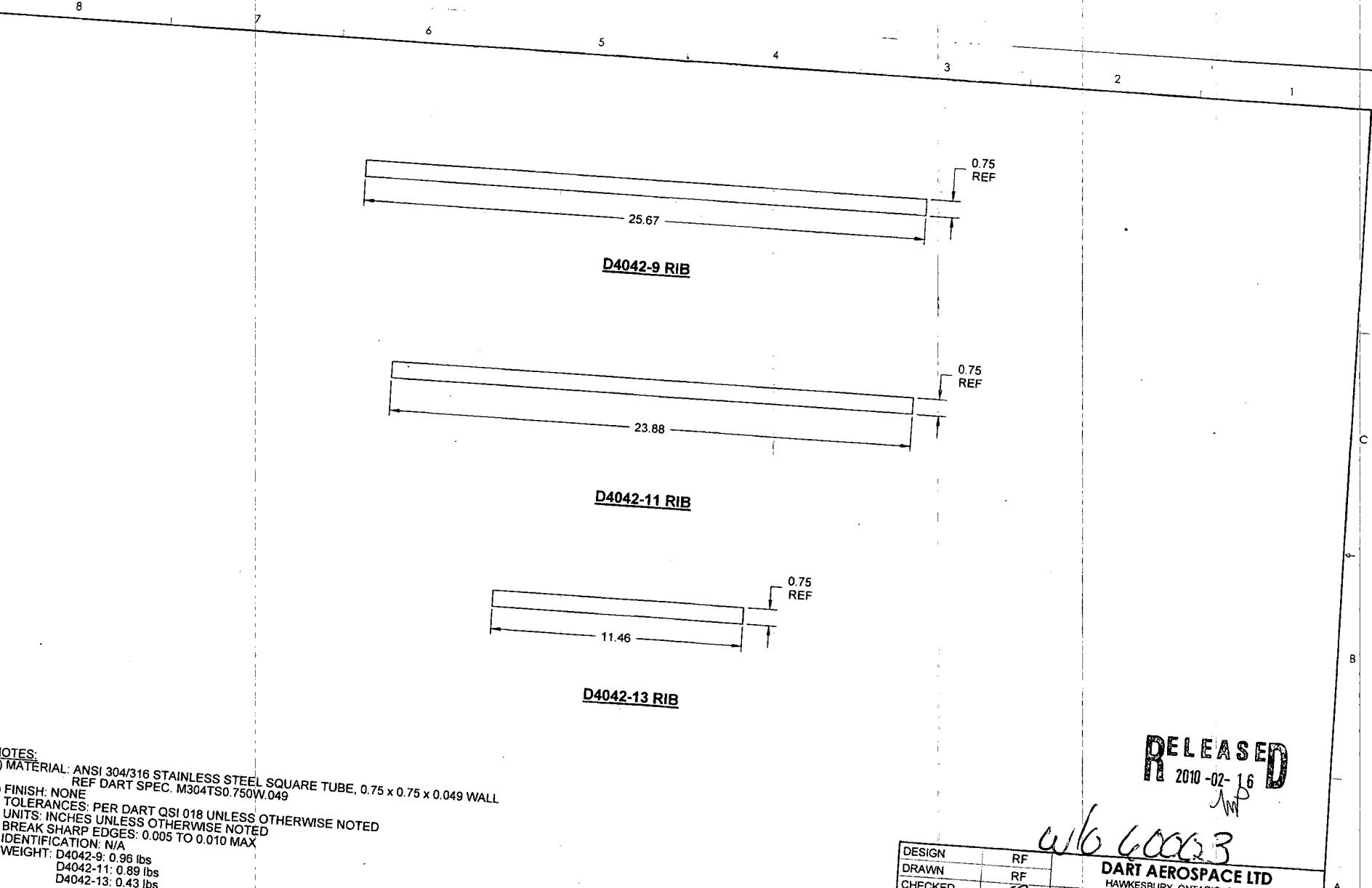
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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2010-02-16

W6 60053

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4042
DRAWN	RF	
CHECKED	<i>RR</i>	
MFG. APPR.	<i>RR</i>	
APPROVED	<i>RP</i>	
DE APPR.	<i>RP</i>	
DATE	10.01.29	REV. A SHEET 11 OF 11 SCALE NTS
TITLE SHORT BASKET BASE ASSY		

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